

Date: Wednesday, 8/8/2007 7:40:39 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NUT PLATE
Job Number : 33842	
Estimate Number : 11262	
P.O. Number :	Part Number : D3415041
This Issue : 8/8/2007 S.O. No. :	Drawing Number : D3415 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 33434	Material :
Written By : <i>JLM 07-08-08</i>	Due Date : 8/15/2007 Qty: 100 Um: Each
Checked & Approved By :	
Comment : Est: A 05.10.03 New issue KJ/JLM	
Est Rev: B Now on Waterjet 07-03-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0138 sf(s)/Unit Total : 1.3755 sf(s)

304/316 .063 Sheet

Batch: *M105061* *B 07-08-09*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3415

Dwg Rev: *B*Prog Rev: *B**B 07-08-09**(192)*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*B 07-08-09*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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*QSP615*

Comment: SECOND CHECK

*07/02/09**(192) counted*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2-C'sink as per Dwg D3415

*MF**07-08-16**(193)*

Date: Wednesday, 8/8/2007 7:40:39 AM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 33842

Part Number: D3415041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

POWDER COATING

POWDER COATING



M105068



(193X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.L. 07/08/29

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



counted

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 07/09/23

(193)

8.0

MS21070L4

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Nut Plate

Pick:

Qty Part Number Description Batch

1 MS21070L4 Nut Plate

M103925 (73)

M105878 70

M105408 (50) SAD 07/09/23

9.0

MS208133C3

MS 20427 F 3-3

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 200.0000 Each(s)

RIVET

Batch:

M118355

~~M105408~~
~~M105~~

SAD 07/09/23

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(P/2) 7

Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut plate as per Dwg D3415

SM 07/10/15
SAD 07/09/23

(188)

11.0

QC5

INSPECT WORK TO CURRENT STEP

counted
count

Comment: INSPECT WORK TO CURRENT STEP

SAD 07/10/15

(188)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

S791

07/10/15

(188)

50

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 33842

Part Number: D3415041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.16
H

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

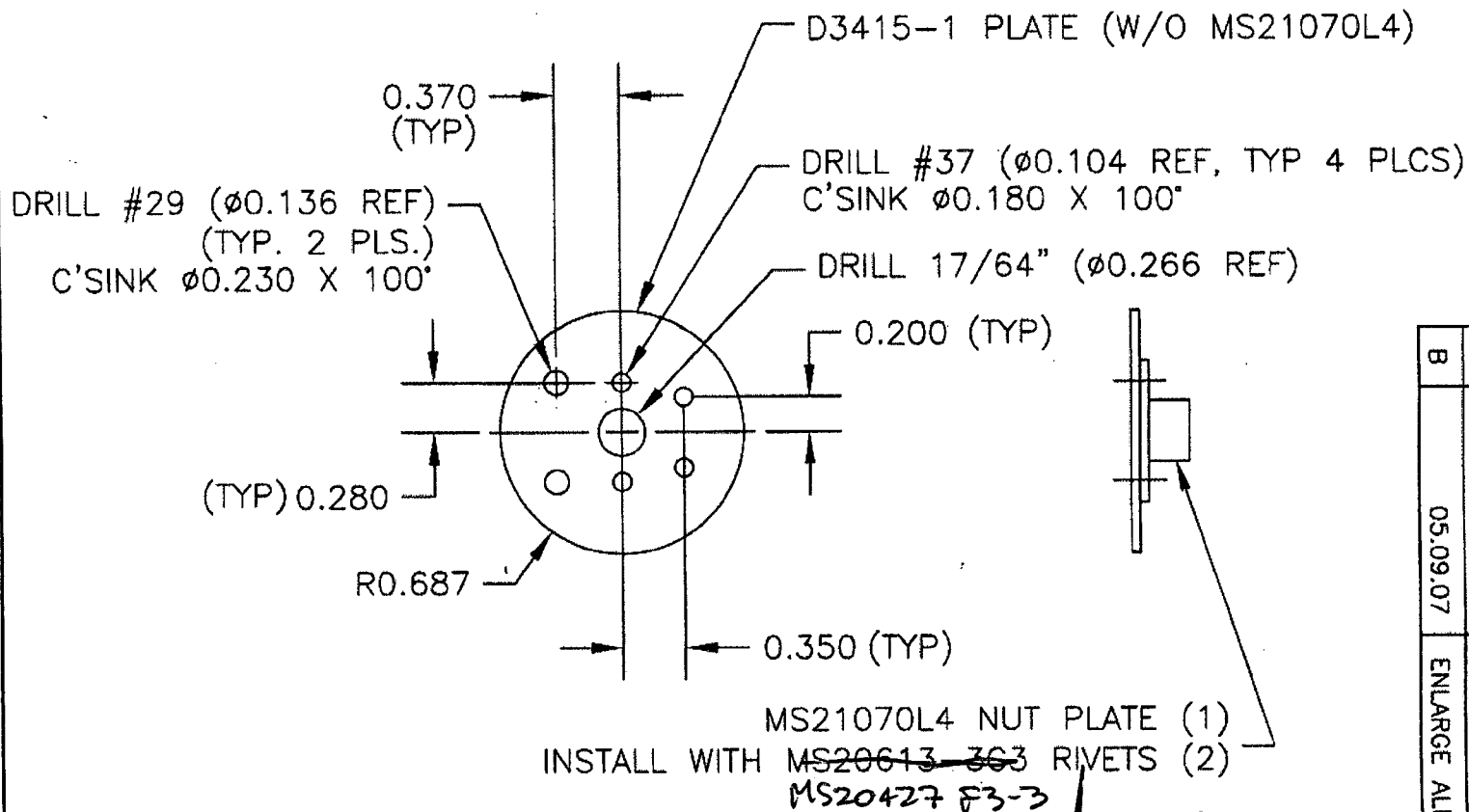


u 07.10.16

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	<i>AK</i>	APPROVED	<i>AK</i>	DRAWING NO.	REV. B
				D3415	SHEET 1 OF 1
DATE	05.09.07			TITLE	SCALE
				NUT PLATE	1:1
A		05.03.16	NEW ISSUE		
B		05.09.07	ENLARGE ALL HOLES FOR POWDER COAT		

09-09-2008



D3415-041 NUT PLATE

- 1) MATERIAL: AISI 304 SS SHEET, 0.063 THICK
(16 GAUGE, REF DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3415-041 PAR #: _____ Fault Category: Prod / Finishing NCR: Yes No DQA: Yes Date: 07/10/15
 QA: N/C Closed: Yes Date: 07/10/15

NCR: <u>33842</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/15	6.0	one nut plate was found with a poor powder coat finish. R.C. Hummon error	<i>[Signature]</i>	Scuff the entire surface front and back and Re Powder coat as per QSI 005	<i>M.H.</i> 07/10/15	<i>[Signature]</i> 07/10/15	<i>[Signature]</i> 07/10/15	<i>[Signature]</i> 07/10/15
07/10/15	10.0	Scrap 5 parts hole was too big, because had to take the rivet out. because Rivet was not good in the process over size the hole of the 5 parts R.C. Hummon error	<i>[Signature]</i>	Scrap, destroy	<i>SAD</i> 07/10/15	<i>[Signature]</i> 07/10/15	<i>[Signature]</i> 07/10/15	<i>[Signature]</i> 07/10/15

NOTE: Date & initial all entries